

Date: Tuesday, 8/7/2007 9:14:55 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE ASSEMBLY
Job Number	: 33832		
Estimate Number	: 11180		
P.O. Number	: N/A	Part Number	: D2282043
This Issue	: 8/7/2007 S.O. No. : N/A	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 33390B	Material	: N/A
Written By	: <u>07/08/07</u>	Due Date	: 8/14/2007
Checked & Approved By	:	Qty:	50 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		

## Additional Product



Seq. #: Machine Or Operation: Description :

1.0 D2281 Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2281 Saddle B33414

07/08/07 (50)

2.0 D22827 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2282-7 tube B33417

07/08/07 (50)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod M102421 / M105138

Dwg Rev: E

07/08/08 (50x)

4.0 DO NOT USE 029 WELD INSPECTION



Comment: WELD INSPECTION

07/08/08 (50)

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Drawing Name: SADDLE ASSEMBLY

Job Number: 33832

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

*ml 07/08/09 50*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/08/10 (50) counter*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*ml 07/08/10*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(50) 07/08/10*

Job Completion



*07/08/10*